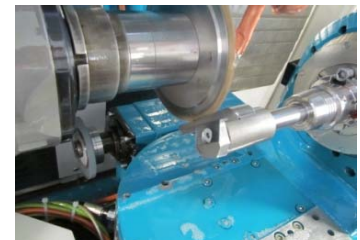


Gear Insert B L79.5 B17 H10

A08-010

After probing sideposition of the insert, 3 passes of pregrinding and 2 passes of finishing are executed. K-Land is ground in one pass on each side with periphery of a 20° wheel.



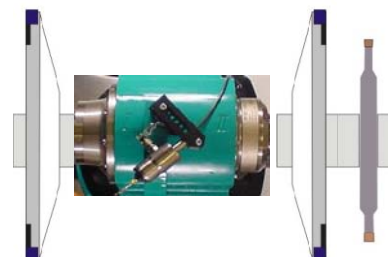
1. Cycletime for Production

Workpiece: Blank L80.5xB17.5xH10.5 Material CARBIDE					
Operations	Probe	Pregrinding	Finish	Kland right	Kland left
Feed [mm/Min]	2000	20	50	90	90
Power [kW]		4	2	1	1
Cutting speed [m/s]		30	32	22	22
Used wheels		1	2	3	3
Grinding time [s]	12	750	203	57	57
Total cycle time	17 Min 58				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12C9 Ø300 D91 C100
2	12C9 Ø300 D64 C125
3	DXF Ø150 D54 2xV20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Control: Fanuc 310i

Accessories: special Clamping, Steady Rest

Responsible engineer: OP, 13.6.14

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

www.schneeberger.ch

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